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(54) Modified thermoplastic polyester molding compositions and articles molded therefrom.

(57) Thermoplastic molding compositions which comprise  
 (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin and a minor  
 proportion of (b) an aromatic polycarbonate resin which may  
 also contain silicone units in combination with (c) a rubbery  
 thermoplastic vinyl polymer which preferably contains olefinic  
 units or a rubbery poly(carbonate-co-ester) resin, provide  
 molded articles of improved impact resistance. Optionally  
 the compositions contain a polyethylene resin as a process-  
 ing and a fibrous reinforcing agent, a mineral filler, and a  
 flame retardant. In preferred embodiments, articles molded  
 from the compositions possess improved impact resistance,  
 lower specific gravity, good tensile strength, improved  
 resistance to distortion at elevated temperatures under load,  
 and improved receptivity for colorants.

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UNITED STATES PATENT APPLICATION

OF: Ronald Lee Dieck, Robert Glenn Thompson  
and Robert James Kostelnik

FOR: MODIFIED THERMOPLASTIC POLYESTER MOLDING  
COMPOSITIONS AND ARTICLES MOLDED THEREFROM

BACKGROUND OF THE INVENTION

15           The present invention relates to modified  
thermoplastic poly(C<sub>2-6</sub> alkylene terephthalate) molding  
compositions which in preferred instances provide molded  
articles possessing improved impact resistance, lower  
specific gravity, improved resistance to distortion under  
20   load, and improved receptivity to colorants. More parti-  
cularly, the invention relates to compositions of (a)  
a (C<sub>2-6</sub> alkylene terephthalate) resin, (b) an aromatic  
polycarbonate resin which may also contain silicone units,  
and (c) a rubbery thermoplastic vinyl addition polymer or  
25   an aromatic poly(carbonate-co-ester) resin.

          Optionally the compositions contain polyethylene  
as a processing aid; a fibrous reinforcing agent; mineral  
fillers; and flame retardants. The invention includes  
30   articles molded from the composition.

35

High molecular weight linear polyesters of C<sub>2-4</sub> glycols with terephthalic acid (and isophthalic acid and other similar dibasic acids) have been available for many years. Certain of these are described in  
5 Whinfield et al. U.S. Patent 2,465,319 and in Pengilly U.S. Patent 3,047,539, incorporated herein by reference.

With the development of molecular weight control, the use of nucleating agents and two-step molding cycles,  
10 polyethylene terephthalate and, in general, the poly-(C<sub>2-6</sub>alkylene terephthalate) resins have become important constituents of injection moldable compositions. Poly-(1,4-butylene terephthalate), because of its very rapid  
15 crystallization from the melt, is uniquely useful as a component of such compositions. Workpieces molded from such polyester resins, alone or combined with reinforcements, in comparison with other thermoplastics possess a high degree of surface hardness, abrasion resistance and gloss, and a low degree of surface friction.

20 Stable polyblends of poly(1,4-butylene terephthalate) and polyethylene terephthalate can be molded into useful unreinforced and reinforced articles. See Fox and Wambach U.S. 3,953,394, incorporated herein by reference.  
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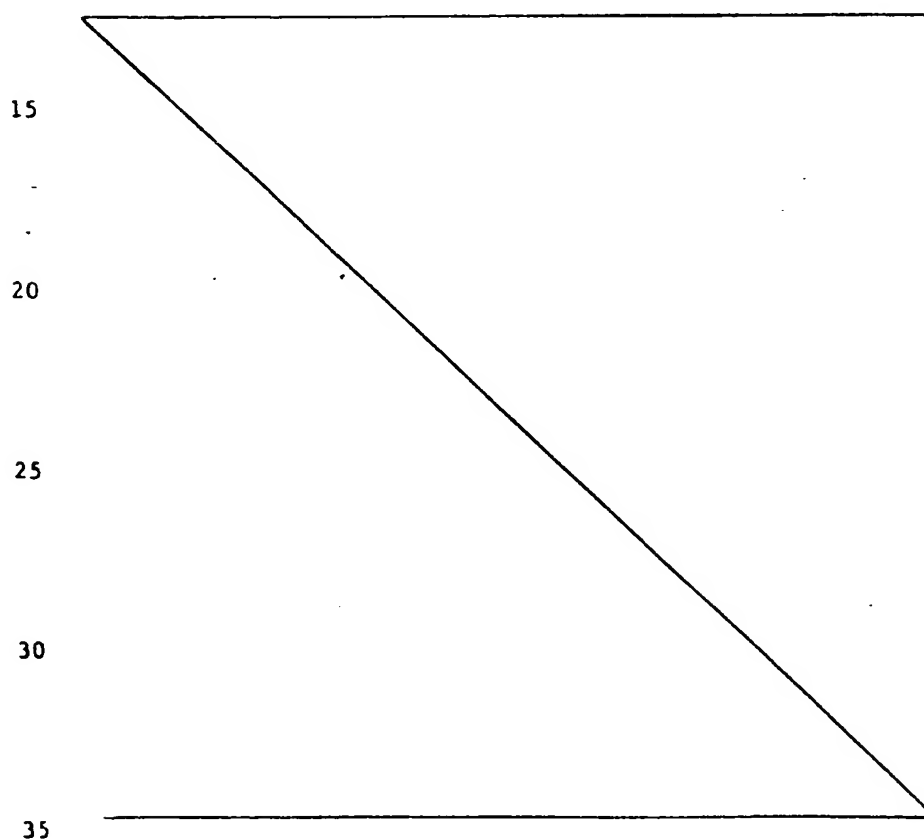
Block copolyesters containing units derived from poly(1,4-butylene terephthalate) and from an aromatic aliphatic or aliphatic polyester are also known. See copending  
30 application U.S. Serial No. 752,325 filed, December 20, 1976, incorporated herein by reference. Such block copolyesters are useful alone as molding resins and also in intimate combination with poly(1,4-butylene terephthalate) and/or polyethylene terephthalate.

35

It has been proposed to increase the impact strengths of such polyesters by adding modifiers. For example, Brinkmann et al. in U.S. 3,591,659 disclose that a useful family of modifiers comprises polyalkyl acrylates, methacrylates and/or ethacrylates. Baron et al. in U.S. 4,044,073 disclose that a useful impact modifier for such polyesters is an aromatic polycarbonate. Schlichting et al. in U.S. 4,022,748 disclose that a rubber-elastic graft copolymer having a glass temperature below  $-20^{\circ}\text{C}$ . is a useful modifier. Lane, U.S. 4,034,013 and Farnham et al., U.S. 4,096,202 disclose that useful impact modifiers comprise multiple-stage polymers having a rubbery first stage and a hard final stage, preferably including units derived from alkyl acrylates, especially the butyl acrylates. Baron et al. in U.S. 4,034,016 disclose an impact modifier combination comprising a blend of a polyurethane and an aromatic polycarbonate. Copending application Serial No. 870,679 filed January 19, 1978, discloses an impact modifier combination comprising a segmented block copolyester and an aromatic polycarbonate, and Cohen et al. copending application Serial No. 957,801 discloses combinations of polyarylate resins and aromatic polycarbonate resins for the purpose. Reinforced, filled and/or flame retardant modifications of such polyesters are also well-known in the art.

It has now been discovered that molding compositions comprising a predominantly poly( $\text{C}_{2-6}$  alkylene terephthalate) resin, including copolyesters thereof, provide moldings of improved impact resistance, flexural and tensile strength and resistance to distortion at elevated temperatures under load, as well as lower specific gravity and improved color receptivity, when the compositions include in intimate admixture a polycarbonate resin and a rubbery vinyl addition resin which preferably contains olefinic

units in the carbon chains thereof, or a poly(carbonate-ester). As is shown below, compositions modified with the polycarbonate resin alone on the one hand, or with the vinyl resin on the other hand, are significantly less tough. As is also shown below, all the new compositions of the present invention can advantageously contain any of the reinforcing fibers (glass and graphite), fillers (talc, clay and mica), stabilizers, colorants, mold release agents and flame retardants and the like which are customarily present in molding compositions based on the poly(alkylene terephthalate) resins.



DESCRIPTION OF THE INVENTION

The invention provides thermoplastic molding compositions comprising (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin and a minor proportion of (b) an aromatic poly-carbonate resin; in combination with (c) a rubbery vinyl addition polymer or a poly(co-carbonate-ester) resin, the combined amounts of (b) and (c) being effective to increase the impact strength of articles molded from said resin (a). Optionally the compositions can also contain polyethylene as processing aid, and one or more fibrous reinforcing agents, mineral fillers, and flame retardants, and the like.

The polyester resins (a) of the composition of the present invention are available commercially. They can be prepared by known methods such as the alcoholysis of dimethyl terephthalate with an appropriate diol (for example, ethylene glycol and 1,4-butanediol) followed by polymerization, or by reacting the acid or its mono- or di-halide with an appropriate diol or mixture of diols. Copolyesters can be prepared in similar manner by replacement of parts of the terephthalate component with another suitable acid component, for example isophthalic acid. Suitable methods are described in U.S. 2,465,319 and U.S. 3,047,539. The preparation of block copolyesters is described in Borman, Dolce and Kramer application Serial No. 752,325 filed on December 20, 1976 and incorporated herein by reference.

Illustratively, suitable high molecular weight polyesters have an intrinsic viscosity of at least about 0.4 deciliters per gram and preferably at least 0.6 deciliters per gram as measured in a 60:40 phenol:tetrachloroethane mixture at 30°C. for poly(ethylene terephthalate)

and at least 0.6 dl./g. and preferably at least 0.8 dl./g. for poly(1,4-butylene terephthalate).

5        Polyesters which are especially useful when  
high melt strength is important are the branched high  
melt viscosity poly(1,4-butylene terephthalate) resins  
which contain a small amount (up to about 5 mol percent  
of the terephthalate units) of a branching component  
which contains at least three ester-forming groups. The  
10    branching component can be one which provides branching  
in the acid unit of the polyester or in the glycol unit,  
and both types of branching components can be present.  
Illustrative of suitable branching components are tri-  
and tetracarboxylic acids such as trimesic acid, pyro-  
15    mellitic acid, and the lower alkyl esters thereof, and  
preferably polyols and especially preferably tetrols such  
as pentaerythritol, triols such as trimethylolpropane,  
and dihydroxy mono- and dicarboxylic acids and derivatives  
such as dimethyl hydroxy terephthalate and the like.

20        The branched poly(1,4-butylene terephthalate)  
resins and methods for their preparation are described  
in Borman, U.S. 3,953,404 incorporated herein by reference.

25        The vinyl addition polymer component (c) of the  
impact modifier combination can be any normally rubbery  
thermoplastic vinyl polymer. Suitable polymers are the  
commercial copolymers of butyl acrylate and styrene;  
butyl acrylate, methyl methacrylate and styrene; butyl  
30    acrylate and methyl methacrylate (Acryloid KM 330 of Rohm  
& Haas Co., Philadelphia, Pa.); EPDM (Epsyn 436) and methyl  
methacrylate and styrene. Other useful vinyl polymers are  
the polyacrylates which are sold under the trade designation  
RXL 6886 by Goodyear Tire & Rubber Co. of Akron, Ohio;  
35    Cyanacryl 770 of American Cyanamid Co. of Wayne, N.J.;

Durostrength 200 of M&T Chemicals Co., Trenton, N.J.; and Polysar S 1006. In general, any of the poly(C<sub>2-4</sub> alkyl acrylates) and methacrylates described in Brinkmann et al. U.S. 3,591,659 can be used, especially those containing units derived from n-butyl acrylate. Without limitation, the polyvinyl resin can be a rubbery elastic graft copolymer having a glass transition temperature below 20°C. as described in Schlichting et al. U.S. 4,022,748, or it can be a multiple stage polymer having a rubbery first stage and a hard, thermoplastic final stage as is described in Farnham et al. U.S. 4,096,202, incorporated herein by reference.

Moreover, the rubbery vinyl addition resins can include those which contain olefinic units in their backbone chains. Such polymers are readily made by including a minor amount, in the range of 2 to 20 mol percent, of a conjugated diene in the initial polymerization mixture.

A large number of conjugated dienes are known which are suitable for the purpose. Illustratively, these include 1,3-butadiene, 2,3-dimethyl-1,3-butadiene, chloroprene and 2-methyl butadiene and mixtures thereof.

Illustrative polymers which contain olefinic units in the chain are the acrylonitrile-butadiene copolymer available under the name Krynac 221, 110C, etc.; the acrylonitrile-butadiene-styrene copolymer prepared by grafting styrene and acrylonitrile on polybutadiene and available from Polysar Corp. of Canada as Polysar XC-501; isobutylene-isoprene copolymer available under the name Polysar Butyl 301; the methyl methacrylate-acrylonitrile-butadiene-styrene copolymer; the methyl methacrylate-butadiene-styrene copolymer; polybutadiene



(available under the designation Taktene 1202); and the butadiene-styrene block copolymer available under the name Kraton G.

5           The aromatic polycarbonate resins which are suitable for use as component (b) are well known, and many suitable resins of this group are disclosed in Encyclopedia on Polymer Science and Technology, Vol. 10, pages 710-727, 1969 Interscience, New York and in Baron  
10 et al. U.S. Patent No. 4,034,016 all incorporated herein by reference. The polycarbonates are produced by reaction of a suitable dihydric phenol compound with phosgene. The reaction is continued until a polycarbonate resin is formed. Because of its ready availability, the ease with which it  
15 reacts with phosgene and the very satisfactory properties which it provides in polymerized form, bisphenol-A is preferred as the starting dihydric phenol compound. A suitable aromatic polycarbonate is available under the trademark LEXAN<sup>®</sup> from General Electric Co. Also suitable  
20 is a poly(carbonate-co-silicone) resin known as Copel 3320.

          The rubbery vinyl addition polymer and the polycarbonate components (b) and (c) are present in respective weight ratios between 10:1 and 1:10 and preferably in a  
25 ratio between 3:1 and 1:3. The combined weights of (b) and (c) are between 5% and 85%, and preferably between 15% and 60% of the weight of the total resin content of the composition.

30           In contemplated embodiments the composition includes reinforcing fillers such as fibrous (filamentous) glass and/or graphite; mineral fillers such as mica, talc and the like, and preferably, clay; and polyethylene or other similar polymers as carrier for the vinyl component.  
35 The filamentous glass suitable for use as reinforcement

in such embodiments is well known to those skilled in the art and is available from a number of manufacturers. For compositions ultimately to be employed for electrical uses, it is preferred to use filaments of a lime-  
5 aluminum boro-silicate glass that is substantially soda-free. This is known as "E" glass. However, other glasses are useful when electrical properties are not important, and there the low soda glass known as "C" glass can be used. The filaments are made by standard  
10 processes, e.g., by steam, air or flame blowing and, preferably, by mechanical pulling. The filaments preferably have diameters between about 0.00012" and 0.00075", but this is not critical to the present invention. The fillers can be untreated or treated with silane. The poly-  
15 ethylene preferably is of the low-density type.

The length of the glass filaments and whether or not they are bundled into fibers and the fibers bundled in turn to yarns, ropes or rovings, or woven into mats and  
20 the like, are also not critical to the invention. However, in preparing the molding compositions, it is convenient to use the filamentous glass in the form of chopped strands about 1/8" to about 2" long. In articles molded from the compositions, on the other hand, fibers of shorter length  
25 may be present because, during compounding, considerable fragmentation occurs. This is desirable, however, because, the best properties are exhibited by thermoplastic injection molded articles in which the filament lengths lie between about 0.0005" and 0.250".

30 The amount of the filler varies widely depending on the strength specifications which are to be met, it being essential only that an amount is employed which is at least sufficient to provide some reinforcement. Preferably, however, the weight of the reinforcing fibers  
35

is between about 1% and 60% of the combined weight of filler and the resinous components of the mixture.

5 It has also been discovered that the polyester compositions of this invention which contain modifiers and fibrous glass exhibit improved impact and flexural properties when the glass is predispersed in the resin.

10 The impact modified polyesters, with and without fibrous reinforcement and filler, can be rendered flame retardant with an effective amount of a conventional flame retardant agent. As is well known, flame retardants can be based on elementary red phosphorus, phosphorus compounds, halogen and nitrogen compounds alone or, preferably,  
15 in further combination with synergists such as antimony compounds. Especially useful are polymeric and oligomeric flame retardant agents comprising tetrabromobisphenol-A carbonate units; see, for example, Wambach, U.S. Patent No. 3,833,685 which is incorporated herein by reference.

20 Other materials such as stabilizers, dyes, pigments, drip retardants and the like can be added for their conventionally employed purposes in conventional amounts.

25 The molding compositions of this invention can be prepared by a number of procedures. In one way, the modifier and any reinforcement (e.g., glass fibers), filler material, fire retardant and other components are  
30 put into an extrusion compounder with the resinous components to produce molding pellets. As a result, the modifier and the other components when present are dispersed in a matrix of the resin. In another procedure, the modifier is mixed with the resins by dry tumbling and then  
35 the mixture is either fluxed on a mill and comminuted or

extruded to form strands which are then chopped. The modifying agents can also be mixed with the resins and directly molded by injection, extrusion or transfer molding or by any other conventional method.

5

It is always important to free all of the ingredients from as much water as possible before subjecting them to any molding operation. The components can be satisfactorily dried by heating them at 100°C. under vacuum for several hours.

10

In addition, it is desirable that the duration of the compounding step should be short to prevent degradation of the polymers and other components. The temperature should be controlled below the polymer degradation point and the heat of friction should be taken into account, the object being to form an intimate mixture among the structural resin component (a) and the modifying polymers (b) and (c).

15

20

Best results are usually obtained when the ingredients are pre-compounded, pelletized and then molded. Pre-compounding can be carried out in conventional equipment. For example, after the components have been thoroughly dried as described, a single-screw extruder is fed with a dry mixture of the ingredients, the screw employed having a long transition section to ensure proper melting. On the other hand, a twin-screw extrusion machine, e.g., a 28-mm. Werner-Pfleiderer machine, can be fed with resin and additives at the feed port and with reinforcement through a downstream port. In either case, a generally suitable machine temperature is between about 450° and 600°F. depending on the melting point of the poly(alkylene terephthalate) in the composition.

25

30

35

The compounded composition can be extruded and cut up into molding compounds such as conventional granules, pellets and other shapes by standard techniques.

5           The composition can be molded in any equipment which is suitable for the molding of fiber-reinforced thermoplastic compositions, e.g., a Newbury-type injection molding machine with conventional cylinder temperatures (450-600°F.) and conventional mold temperatures  
10       (150°-200°F.), the molding temperature being such that the resinous components reach their fusion point.

The invention is further illustrated by the examples which follow. These examples are best embodiments of the invention, and the invention is not to be  
15       construed in limitation thereof. Parts are by weight except where otherwise stated.

#### EXAMPLE 1

20           The following illustrates the effect of the combination of a rubbery vinyl polymer containing olefinic linkages in the chain and an aromatic polycarbonate in improving the impact strength of a poly(C<sub>2-6</sub> alkylene  
25       terephthalate) resin molding which contains glass fiber reinforcement and a mineral filler.

To 100 parts of a commercial poly(1,4-butylene terephthalate) resin (VALOX 310 of General Electric Co.)  
30       were added 15 parts of a rubbery vinyl acrylonitrile-butadiene-acrylonitrile block copolymer, 15 parts of a poly(bisphenol-A carbonate) resin (LEXAN 135 of General Electric Co.) 30 parts of glass fibers (chopped), 10 parts of clay filler, and 15 parts of poly(ethylene terephthalate)  
35       as supplementary resin.

All components are granular and were tumble mixed until a uniform composition was obtained. This composition was dried overnight at 110°C., then extruded in a laboratory 1-3/4" Sterling Machine at 250°C. The chopped pellets and the blend were injection molded into standard ASTM test parts. The test parts possessed improved impact strength as the result of the presence of the supplementary resins therein.

10

EXAMPLE 2

The following illustrates the effect of the addition of poly(bisphenol-A carbonate)resin in combination with a variety of vinyl polymers in improving the impact strength of molded articles prepared with poly(ethylene terephthalate) resin as the major component.

The following compositions were mixed, dried, extruded and then molded in accordance with the method of Example 1.

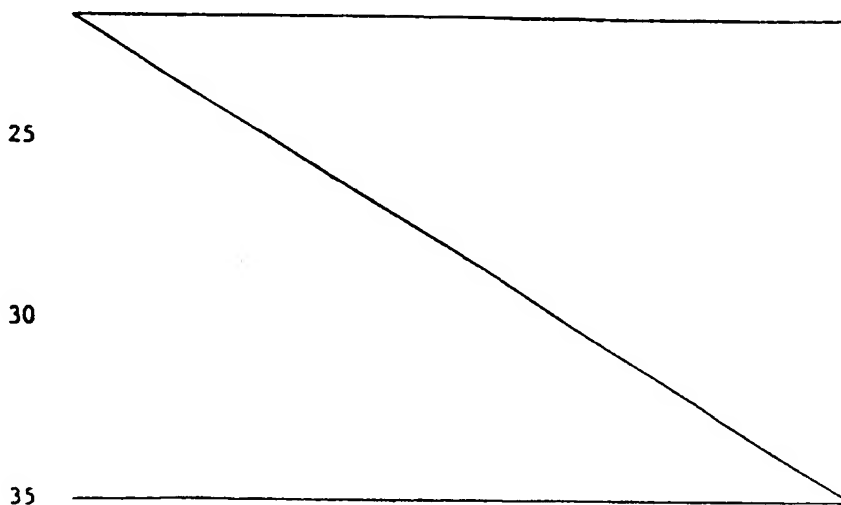


Table 2A

Component		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	PET <sup>1</sup>	68.3	68.3	68.2	58.2	48.3	48.3
	Sodium benzoate <sup>2</sup>	--	--	--	0.1	--	--
5	Acryloid KM 330 <sup>3</sup>	15	--	--	15	--	--
	Methyl methacrylate butadiene-styrene copolymer	--	15	--	--	10	--
	Kraton 1651G <sup>4</sup>	--	--	15	--	--	10
10	LEXAN (R) <sup>5</sup>	15.0	15	15	15	10	10
	IRGANOX 1093 <sup>6</sup>	.15	.15	.15	.15	.15	.15
	Ferro-904 <sup>7</sup>	.05	.05	.05	.05	.05	.05
	Microthene FN 510 <sup>8</sup>	1.5	1.5	1.5	--	--	--
	Glass	--	--	--	10	30	30
15	Polyethylene <sup>9</sup>	--	--	--	1.5	1.5	1.5

<sup>1</sup> poly(ethylene terephthalate)

20 <sup>2</sup> nucleating agent

<sup>3</sup> a butyl acrylate and methyl methacrylate core-shell copolymer of Rohm & Haas Co.

25 <sup>4</sup> a hydrogenated butadiene-styrene block copolymer of Shell Chemical Co.

<sup>5</sup> a poly(bisphenol-A carbonate) from General Electric Co.

<sup>6</sup> an anti-oxidant stabilizer from Ciba-Geigy Co.

30 <sup>7</sup> a phosphite stabilizer from Ferro Co.

<sup>8</sup> a low density polyethylene, fine grind powder

<sup>9</sup> a low density polyethylene, pelletized

35

Test samples prepared from each of the above compositions had the following physical properties:

Table 2B

5	Properties	Compositions					
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	Heat Distortion, °F., 66 psi	176	166	158	180	191	192
	Notched Izod, ft.lb./in.	1.9	1.9	1.5	2.0	1.9	2.0
10	Unnotched Izod, ft.lb./in.	nb*	nb	nb	11.87	14.60	15.02
	Flex, strength, 10 <sup>6</sup> psi	10430	10999	9003	14304	25276	23174
15	Flex, modulus, 10 <sup>6</sup> psi	0.282	0.282	0.257	0.452	0.905	0.781
	Tensile Strength, psi	6483	6645	5457	9660	16597	14677
	% Elongation	52	142	89	--	--	--
20	Specific Gravity	1.280	1.256	1.229	1.325	1.494	1.456
	Gardner Impact, bottom, in.-lbs.	--	--	--	8	8	10
	Gardner Impact, top, in.-lbs.	--	--	--	32	40	46
25	Gardner Impact, dislodge, in.-lbs.	325	470	150	100	70	70
	Melt Viscosity (pellets), poises at 510°F.	3684	2889	1075	2781	13660	9039

30

\*nb - No break

The impact strength of molded articles prepared with poly(ethylene terephthalate) as the major component was improved by the addition of a poly(bisphenol-A carbonate) in combination with a vinyl polymer.

35



EXAMPLE 3

The following illustrates the effect of a minor amount of a poly(bisphenol-A carbonate) resin in combination with a minor amount of one of several rubbery vinyl polymers in improving the impact strength of poly(1,4-butylene terephthalate) resin moldings.

Table 3A

10	Component	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	Valox 315 <sup>1</sup>	68.3	68.3	68.3	68.3	68.3	68.3
	Lexan 135-111	15.0	15.0	15.0	15.0	15.0	15.0
	Microthene FN-510	1.5	1.5	1.5	1.5	1.5	1.5
	Irganox 1093	.15	.15	.15	.15	.15	.15
15	Ferro 904	.05	.15	.05	.05	.05	.05
	Durostrength 200 <sup>2</sup>	15	--	--	--	--	--
	Polysar XC 501 <sup>3</sup>	--	15	--	--	--	--
	Gulf P 218 <sup>4</sup>	--	--	15	--	--	--
	Hycar 211-21-95-1 <sup>5</sup>	--	--	--	15	--	--
20	Hycar 211-21-96-1 <sup>6</sup>	--	--	--	--	15	--
	Hycar 211-21-97-1 <sup>7</sup>	--	--	--	--	--	15

<sup>1</sup> poly(1,4-butylene terephthalate) resin of General  
25 Electric Co.

<sup>2</sup> butylacrylate-methyl methacrylate copolymer from  
Metal and Thermit Co.

<sup>3</sup> acrylonitrile-butadiene copolymer from Polysar Corp.,  
30 Canada

<sup>4</sup> ethylene copolymer

<sup>5-7</sup> acrylonitrile-butadiene rubbers from B.F. Goodrich  
35 Chemical Co.

Each of the above compositions were mixed, dried, extruded and then molded into test pieces by the method of Example 1. The test pieces had the following properties:

5

		<u>Table 3B</u>					
		<u>Compositions</u>					
<u>Properties</u>		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	Heat distortion,						
10	°F., 66 psi	198	218	240	236	208	190
	Heat distortion,						
	°F., 264 psi	100	--	123	128	129	125
	Notched Izod,						
	ft.-lbs./in.	5.17	7.95	2.40	2.83	2.61	4.67
15	Unnotched Izod,						
	ft.-lbs./in.	nb	nb	nb	nb	nb	nb
	Flex strength,						
	psi	10668	10377	9835	10034	9994	9690
	Flex modulus,						
20	psi	281735	281735	261713	272791	261735	267137
	Tensile strength,						
	psi	6496	6189	6025	6080	6189	5847
	% Elongation	177	214	160	130	114	68
	Specific gravity	1.254	1.230	1.210	1.247	1.249	1.246
25	Gardner (no collar)						
	in.-lbs.	480	480	470	460	480	420
	Gardner Impact						
	dislodge, in.-lbs.	465	465	480 <sup>+</sup>	440	460	450
	Melt Viscosity						
30	(pellets), poises						
	at 510°F.	2626	7545	6752	6433	6411	5463

The impact strength of poly(1,4-butylene terephthalate) resin moldings is improved by addition of a poly(bisphenol-A carbonate) resin in combination with a rubbery vinyl polymer.

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EXAMPLE 4

The following illustrates the improved impact strength imparted to a poly(alkylene terephthalate) molding resin when a small uniformly-distributed amount of a poly(carbonate-co-silicone) resin is added alone, or with a polycarbonate homopolymer or a rubbery vinyl polymer.

Six molding compositions were prepared following the method of Example 1 as follows:

		<u>Table 4A</u>					
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
15	Valox 315	68.3	68.3	68.3	78.3	68.3	68.3
	Microthene						
	FN-510	1.5	1.5	1.5	1.5	1.5	1.5
	Irganox 1093	.15	.15	.15	.15	.15	.15
	Ferro 904	.05	.05	.05	.05	.05	.05
20	Copel 3320 <sup>1</sup>	--	15	15	20	15	15
	KM 330 <sup>2</sup>	15	15	--	--	--	--
	Lexan 135	15	--	15	--	--	--
	Kraton G	--	--	--	--	15	--
	KMBS <sup>3</sup>	--	--	--	--	--	15

25

<sup>1</sup> poly(bisphenol-A carbonate-silicone).

<sup>2</sup> butylacrylate-methyl methacrylate core-shell copolymer

30 <sup>3</sup> methyl methacrylate-butadiene-styrene copolymer

35

The physical properties of test pieces prepared as in Example 1 of each of the compositions were as follows:

5	Properties	Table 4B					
		Compositions					
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	Heat distortion,						
	°F., 264 psi	134	117	137	122	120	120
	Notched Izod,						
10	1/4", ft. lbs./in.	17.3	20.7	17.4	12.4	3.4	3.4
	Notched Izod,						
	1/8", ft. lbs./in.	21.90	22.56	20.54	15.71	21.01	19.50
	Unnotched Izod,						
	ft. lbs./in.	5nb*	5nb	5nb	5nb	5nb	5nb
15	Flex Strength,						
	psi	10761	7694	10695	9280	6808	8064
	Flex Modulus,						
	psi	291285	20705	277191	249070	173594	217542
	Tensile strength,						
20	psi	6394	4653	6509	5530	4196	4766
	% Elongation	207	238	277	315	302	351
	Specific gravity	1.247	1.238	1.247	1.255	1.193	1.219
	Gardner Impact						
	dislodge, in. lbs.	480+	480+	480+	480+	480+	480+
25	Melt Viscosity						
	(pellets), poises						
	at 266°C.	10095	5139	6434	4337	6142	5543

\* 5 specimens tested did not break.

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The addition of a poly(carbonate-co-silicone) resin, added alone or in combination with either a poly-carbonate homopolymer or a rubbery vinyl polymer to a poly-(ethylene terephthalate) molding resin provides molded articles having a marked increase in impact strength.

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EXAMPLE 5

The following illustrates the effect of a poly(carbonate-co-silicone) resin and a resin comprising a polyester-ether block copolymer consisting of polybutylene terephthalate and polybutylene oxide blocks in combination with glass fibers in improving the impact resistance of poly(1,4-butylene terephthalate) resin molded articles.

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The following compositions were prepared in accordance with the method of Example 1:

Table 5A						
15	<u>Component</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>
	VALOX 300	49.85	49.85	54.85	59.85	64.85
	Glass	30.00	30.00	30.00	30.00	30.00
	PE-18 <sup>1</sup>	.10	.10	.10	.10	.10
	Ferro	.05	.05	.05	.05	.05
20	Copel 3320	--	20	15	10	5
	Hytrel 4056 <sup>2</sup>	20	--	--	--	--

<sup>1</sup> pentaerythritol tetrastearate

25 <sup>2</sup> Hytrel 4056 from Dupont

Test pieces prepared by the extrusion - molding process of Example 1 had the following physical properties:

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Table 5B

Property	Composition				
	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>
Heat distortion,					
5 °F., 264 psi	317	357	375	378	393
Notched Izod,					
ft.-lbs./in.	3.46	2.58	2.54	2.37	2.22
Unnotched Izod,					
ft.-lbs./in.	15.46	9.74	11.06	14.29	14.91
10 Flex Strength,					
psi	17186	14317	17490	21072	23928
Flex Modulus,					
psi	636513	636513	687434	781175	904518
Tensile strength,					
15 psi	10837	9429	11541	13653	15147
Specific gravity	1.488	1.469	1.482	1.495	1.518
Gardner Impact					
(bottom), in.-lbs.	12	12	12	12	12
Gardner Impact					
20 (top), in.-lbs.	48	40	44	44	40
Gardner Impact					
(dislodge), in.-lbs.	120	96	92	84	72
Melt viscosity					
(pellets) in poises					
25 at 250°C.	10662	8462	10662	12099	12599

The impact resistance of poly(1,4-butylene terephthalate) resin molded articles is improved by the addition of a resin comprising a polyester-ether block copolymer of polybutylene terephthalate and polybutylene oxide blocks in combination with glass fibers. Impact resistance is likewise improved by addition of poly(carbonate-co-silicone) in combination with glass fibers.

EXAMPLE 6

The following illustrates the improved impact resistance obtained if a small amount of a poly(carbonate-ester) is added to a molding resin composition containing a poly(alkylene terephthalate) and a vinyl copolymer.

Six molding compositions were prepared in accordance with the method of Example 1 as follows:

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Table 6A

Component	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
Valox 315	68.3	68.3	78.3	68.3	68.3	68.3
Microethene						
15 FN-510	1.5	1.5	1.5	1.5	1.5	1.5
Irganox 1093	.15	.15	.15	.15	.15	.15
Ferro 904	.05	.05	.05	.05	.05	.05
Copolyester-carbonate resin <sup>1</sup>	15	15	20	15	15	--
20 KM 330	15	--	--	--	--	--
Lexan 135	--	15	--	--	--	15
Kraton G	--	--	--	15	--	--
MMBS	--	--	--	--	15	--

25 <sup>1</sup> a poly(carbonate-ester) made by interfacially condensing bisphenol-A, phosgene and a mixture of terephthaloyl chloride and isophthaloyl chloride.

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The compositions were injection molded as in Example 1 into test pieces having the following properties:

5	Properties	<u>Table 6B</u>					
		<u>Compositions</u>					
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
	Heat Distortion, °F., 264 psi	142	153	153	145	153	154
10	Notched Izod, (1/4"), ft.-lbs./ in.	13.90	--	--	3.40	17.37	17.37
	Notched Izod, (1/8"), ft.-lbs./ in.	19.58	1.54	1.28	24.11	20.19	22.19
15	Unnotched Izod, ft.-lbs./in.	5nb	5nb	5nb	5nb	5nb	5nb
	Flex Strength, psi	10272	13206	12595	8779	10972	10695
20	Flex Modulus, psi	256505	324261	330497	232241	277191	272791
	Tensile Strength, psi	6300	8382	7546	5658	6677	6364
	% Elongation	154	69	182	108	225	183
25	Specific gravity	1.245	1.260	1.270	1.206	1.226	1.252
	Gardner Impact (dislodge) (in.- lbs.)	425	480+	480+	475	480	480
30	Melt Viscosity (pellets), poises at 266°C.	7764	7053	5711	7753	10460	9888



The addition of a poly(carbonate ester) to a molding resin of a polyalkylene terephthalate and a vinyl copolymer improves the impact strength of articles molded therewith.

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EXAMPLE 7

Several molding compositions were prepared in accordance with the method of Example 1 to illustrate the impact resistance obtained if various vinyl and ester resins are added to molding compositions containing, as the principal structural polymer, a polyalkylene terephthalate resin. The compositions were comprised as follows:

Table 7A

	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>
15 <u>Component</u>						
Valox 295 <sup>1</sup>	33.8	33.8	33.8	28.8	33.8	28.8
RL 1624 <sup>2</sup>	18	18	18	18	18	18
Glass	30	30	30	30	30	30
Irganox 1093	.15	.15	.15	.15	.15	.15
20 Ferro 904	.05	.05	.05	.05	.05	.05
Teflon 6	.5	.5	.5	.5	.5	.5
KM 330	--	--	10	15	15	--
Copel 3320	--	--	--	--	10	15
Hytrel 4056	10	10	--	--	--	--
25 Sb <sub>2</sub> O <sub>3</sub> (Conc.) <sup>3a</sup>	--	7.5	7.5	7.5	7.5	7.5
Sb <sub>2</sub> O <sub>3</sub> (Conc.) <sup>3b</sup>	7.5	--	--	--	--	--

<sup>1</sup> poly(1,4-butylene terephthalate), I.V. about 0.85 dl/g.

30 <sup>2</sup> flame retardant copolycarbonate of bisphenol-A and tetrabromobisphenol-A, 50:50 wt.%.  
<sup>3a</sup> Chemetron SbO<sub>3</sub> concentrate in polyethylene from PPG, Inc.

<sup>3b</sup> Metal and Thermit Company Sb<sub>2</sub>O<sub>3</sub> concentrate in polyethylen

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Each composition was dried for a minimum of four hours at 250°F. The compositions were then compounded in a Prodex single screw extruder using a vibratory feeder and working at between 500°-540°F. at 100 rpm. The compositions were molded a 3 oz. Van Dorn injection molding machine. Spiral flow measurements were made using a 1/16 inch channel and 600 psi injection pressure, no boost pressure and 100 psi back pressure, with the barrel temperature set at 480°F. Tests of the physical properties of the moldings were performed. The results are summarized in Table 7B below:

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Properties	Table 7B					
	1	2	Compositions			6
			3	4	5	
Heat Distortion °F., 66 psi	390	402	393	384	398	390
Heat Distortion °F., 264 psi	392	319	314	290	344	309
Spiral Flow, in.	7.3	6.3	4.2	3.5	6.3	6.6
Notched Izod, ft.-lbs./in.	1.36	1.84	2.02	2.38	1.87	1.95
Unnotched Izod, ft.-lbs./in.	9.49	11.66	12.83	12.24	11.60	10.82
Flex strength, psi	17714	19750	20120	18494	20636	16458
Flex modulus, psi	845205	859292	904518	758199	920670	781175
Tensile strength, psi	12267	14272	14656	13056	14763	11691
Specific gravity	1.637	1.635	1.601	1.572	1.612	1.599
Gardner Impact (bottom), in. lbs.	16	24	32	28	20	20
Gardner Impact (top), in. lbs.	40	48	52	48	52	44
Gardner Impact (dislodge), in. lbs.	44	64	68	88	66	68
Melt Viscosity (pellets), poises at 266°C.	7600	9452	45859	85926	13456	21682
Flammability, U.L. Bulletin 94, 30 mils thickness	V-O	V-O	V-O	V-O	V-O	V-O

EXAMPLE 8

The following illustrates the effectiveness of two rubbery alkyl acrylate-styrene copolymers in improving the impact strength of polyterephthalate-polycarbonate moldings.

Table 8A

10	<u>Component</u>	<u>1</u>	<u>2</u>
	Valox 315	69.8	69.8
	Lexan 135	15	15
	Irganox 1093	.15	.15
15	Ferro 904	.05	.05
	RXL 686 <sup>1</sup>	15	--
	P 19100-71B <sup>2</sup>	--	15
<hr/>			
20	<sup>1</sup> methyl methacrylate-styrene copolymer' from Goodyear Tire and Rubber Company.		
	<sup>2</sup> butylacrylate-styrene copolymer from Goodyear Tire and Rubber Company		

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The resulting compositions were then injection molded in accordance with the procedure of Example 1 into test strips. The properties of the resulting test strips were as follows:

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Table 8B			
	<u>Properties</u>	<u>Compositions</u>	
		<u>1</u>	<u>2</u>
	Heat distortion °F.,		
10	264 psi	144	155
	Notched Izod (1/4"),		
	ft.-lbs./in.	9.79	--
	Notched Izod (1/8"),		
	ft.-lbs./in.	19.73	2.03
15	Unnotched Izod, ft.-lbs./in.	5nb	5nb
	Flex strength, psi	10089	12009
	Flex Modulus, psi	266861	390587
	Tensile strength, psi	6109	7140
	% Elongation	194	212
20	Specific Gravity	1.273	1.254
	Gardner Impact		
	(dislodge), in.-lbs.	450	425
	Melt Viscosity		
	(pellets), poises at 510°F.	8751	5682

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EXAMPLE 9

The following illustrates the effectiveness of five additional rubbery polymers in improving the impact strength of polyterephthalate-polycarbonate moldings.

Table 9A

<u>Component</u>		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>
	Valox 315	68.3	68.3	68.3	68.3	68.3
10	Lexan 135	15	15	15	15	15
	Microthene FN-510	1.5	1.5	1.5	1.5	1.5
	Irganox 1093	.15	.15	.15	.15	.15
	Ferro 904	.05	.05	.05	.05	.05
	5619-32-4 <sup>1</sup>	15	--	--	--	--
15	5619-32-6 <sup>2</sup>	--	15	--	--	--
	5619-32-9 <sup>3</sup>	--	--	15	--	--
	5619-32-10 <sup>4</sup>	--	--	--	15	--
	5619-32-11 <sup>5</sup>	--	--	--	--	15

20 1-5 Goodyear Tire and Rubber Company rubbery vinyl addition polymer resins.

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The compositions were injection molded in accordance with the procedure of Example 1 to form test pieces which had the following properties:

5	<u>Properties</u>	<u>Table 9B</u>				
		<u>Compositions</u>				
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>
	Heat Distortion					
	°F., 264 psi	132	132	135	144	139
10	Notched Izod					
	(1/4"), ft.lbs./in.	5.68	11.67	14.16	14.42	7.02
	Notched Izod					
	(1/8"), ft.lbs./in.	16.32	16.16	18.69	18.53	15.01
	Unnotched Izod,					
15	ft.lbs./in.	5nb	nb	nb	nb	nb
	Flex strength,					
	psi	9915	9968	9796	9981	11488
	Flex modulus,					
	psi	263049	264398	256505	264398	298020
20	Tensile strength,					
	psi	6080	6020	6195	6208	7021
	% Elongation	252	277	262	138	186
	Specific Gravity	1.236	1.230	1.230	1.245	1.243
	Gardner Impact					
25	in.lbs.(no collar)	480	480	480	480	480
	Gardner Impact,					
	in.-lbs.(dislodge)	425	425	400	450	480
	Melt Viscosity					
	(pellets), poises					
30	at 510°F.	14001	7547	10759	13228	7770

EXAMPLE 10

The following illustrates the comparative effectiveness of a rubbery polysiloxane-polycarbonate block copolymer and two rubbery vinyl polymers, each containing acrylonitrile, butadiene and styrene units as agents for improving the impact strength of molded articles of polyterephthalate polycarbonate resin compositions.

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		<u>Table 10A</u>			
		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>
Component					
Valox 315		68.3	68.3	68.3	68.3
Lexan 135		15	15	--	--
15	Irganox 1093	.15	.15	.15	.15
	Ferro 904	.05	.05	.05	.05
	Microthene FN-510	1.5	1.5	1.5	1.5
	Copel 3320	--	--	15	15
	Blendex 310 <sup>1</sup>	15	--	15	--
20	Polysar XC501 <sup>2</sup>	--	15	--	15

<sup>1</sup> acrylonitrile-butadiene-methyl methacrylate-styrene copolymer, Borg Warner Co.

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<sup>2</sup> acrylonitrile-styrene polybutadiene graft copolymer, Polysar Corp., Canada

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Table 10B

<u>Properties</u>		<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>
Heat Distortion					
°F., 264 psi		154	131	122	118
5	Notched Izod				
	(1/4"), ft.-lbs/in.	2.80	3.94	3.86	12.11
Notched Izod					
	(1/8"), ft.-lbs/in.	10.30	8.58	15.39	14.30
Flex Strength,					
10	psi	10708	9915	8328	7139
Flex modulus,					
	psi	291285	277191	232241	193099
Tensile Strength,					
	psi	6656	5888	5184	4096
15	% Elongation	214	229	246	279
Specific Gravity		1.225	1.225	1.210	1.214
Gardner Impact					
(dislodge),					
	in-lbs.	480	425	400	350
20	Melt viscosity				
	(pellets), poises				
	at 510°F.	9566	10429	5259	5808

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EXAMPLE 11

The following illustrates the comparative effectiveness of certain butadiene copolymers and a butadiene homopolymer in improving the impact strength of polybutylene terephthalate moldings.

Table 11A

	<u>Component</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>
10	VALOX	80	80	80	80	80	80	80	80
	Polysar								
	Butyl 301 <sup>1</sup>	20	--	--	--	--	--	--	--
	Polysar								
	Butyl 111 <sup>2</sup>	--	20	--	--	--	--	--	--
15	Krynac 27.50 <sup>3</sup>	--	--	20	--	--	--	--	--
	Krynac 34.60 <sup>4</sup>	--	--	--	20	--	--	--	--
	Krynac 806 <sup>5</sup>	--	--	--	--	20	--	--	--
	Krynac 1100 <sup>6</sup>	--	--	--	--	--	20	--	--
	Krynac 221 <sup>7</sup>	--	--	--	--	--	--	20	--
20	Taktene <sup>8</sup>	--	--	--	--	--	--	--	20

1-2 Rubbery isobutylene-isoprene copolymers, Polysar Corp.

3-8 Rubbery acrylonitrile-butadiene copolymers.

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The resulting compositions were compounded by the method of Example 1 and were injection molded to form test pieces. The properties of the test pieces were as follows:

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Table 1111

Properties	Compositions							
	1	2	3	4	5	6	7	8
Notched Izod, ft.-lbs./in.	2.91	3.41	3.73	3.90	3.44	4.02	4.59	2.98
Unnotched Izod,								
ft.-lbs./in.*	34.7	32.0	27.4	29.3	33.6	25.9	33.1	22.4
Flex Strength, psi	8408	8408	8209	8487	8765	8606	8566	7930
Flex Modulus, psi	243770	245512	229144	223192	238692	235422	235422	229440
Tensile Strength, psi	5453	5333	5252	5408	5448	5305	5431	5120
% Elongation	99.9	123.7	192.8	184.5	246.3	209	259.4	192
Gardner Impact								
(dislodge), in.-lbs.	108	450	150	200	80	150	300	350
Melt Viscosity (pellets),								
266°C.	3697	3963	5787	6781	3546	3890	5472	7108
Melt Viscosity (pellets),								
poises at 250°C.	6389	6319	9319	12073	7342	7095	10166	12426

\* unnotched Izod - 1,2,6 and 7 - several specimens did not break

The above-mentioned patents and/or patent applications are incorporated herein by reference. Obviously, other modifications and variations of the present invention are possible in the light of the above teachings. For example, the reinforced and/or filled compositions can be provided with stabilizers, and other polyesters and vinyl polymers can be used which are closely related to and which provide substantially the same results as those which have been specifically disclosed above. It is, therefore, to be understood that changes may be made in the particular embodiments described above which are within the scope of the invention as defined in the appended claims.

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CLAIMS

1. A thermoplastic molding composition comprising:
  - 5 (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin and a minor proportion of
  - (b) an aromatic polycarbonate resin combined with
  - (c) a rubbery vinyl addition polymer, the
  - 10 combined amounts of (b) and (c) being effective to increase the impact strength of articles molded from said component (a).
2. A composition according to Claim 1 wherein  
15 said poly(C<sub>2-6</sub> alkylene terephthalate) resin is poly(1,4-butylene terephthalate).
3. A composition according to Claim 1 wherein  
said poly(C<sub>2-6</sub> alkylene terephthalate) resin is poly-  
20 (ethylene terephthalate).
4. A composition according to Claim 1 wherein  
the poly(C<sub>2-6</sub> alkylene terephthalate) resin is a co-  
polyester of poly(1,4-butylene terephthalate).
- 25 5. A composition according to Claims 2 or 4  
also including poly(ethylene terephthalate).
6. A composition according to Claim 1 wherein  
30 said rubbery vinyl polymer contains acrylic units.
7. A composition according to Claim 1 wherein  
said polycarbonate resin is a poly(bisphenol-A carbonate).

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8. A composition according to Claim 1 wherein said polycarbonate resin is a poly(bisphenol-A carbonate-co-silicone).

5 9. A composition according to Claim 1 wherein said rubbery vinyl polymer comprises substantially linear carbon chains.

10 10. A composition according to Claim 9 wherein the linear carbon chains of said polymer contain olefinically unsaturated double bonds.

15 11. A composition according to Claim 1 which also includes (d) a poly(C<sub>2-6</sub> alkylene oxide-co-C<sub>2-6</sub> alkylene terephthalate) resin to improve impact strength.

20 12. A composition according to Claim 1 which also includes (e) poly(carbonate-co-ester) resin to improve impact strength.

25 13. A composition according to Claim 1 wherein the polycarbonate resin is a poly(bisphenol-A carbonate-co-silicone) resin and the vinyl polymer is a styrene-butadiene-block copolymer.

30 14. A composition according to Claim 13 wherein the vinyl polymer is radial teleblock copolymer of styrene and butadiene.

35 15. A composition according to Claim 12 wherein the vinyl polymer is a butadiene-methyl methacrylate-styrene copolymer.

16. A composition according to Claim 1 which also includes (f) an additive selected from a fibrous reinforcing agent; a mineral filler; a stabilizer; a mold release agent; a dye; a pigment; a flame retardant, or a mixture of any of the foregoing.

17. A composition according to Claim 1 wherein the rubbery vinyl addition polymer (c) is selected from the group consisting of:

- an acrylonitrile-butadiene copolymer;
- an acrylonitrile-butadiene-acrylonitrile block copolymer;
- an acrylonitrile-butadiene-styrene copolymer;
- an acrylonitrile-butadiene-methyl methacrylate-styrene copolymer;
- a random  $C_{1-4}$  alkyl  $C_{3-4}$  acrylate-styrene copolymer;
- a butadiene-methyl methacrylate styrene copolymer;
- a butyl acrylate-styrene copolymer;
- a butyl acrylate-methyl acrylate copolymer;
- a methyl methacrylate-styrene linear or radial block copolymer;
- an ethylene-propylene diene rubber; and
- a mixture of any of the foregoing.

18. A composition according to Claim 1 wherein said polycarbonate resin is a poly(carbonate-co-ester) resin.

19. A composition according to Claim 18 which also includes (g) a polyester copolymer.

20. A composition according to Claim 18 wherein the poly(C<sub>2-6</sub> alkylene terephthalate) is a poly(ethylene terephthalate).

5           21. A composition according to Claim 18 wherein the poly(C<sub>2-6</sub> alkylene terephthalate) is a poly(1,4-butylene terephthalate).

10           22. A composition according to Claim 18 which also includes (f) an additive selected from a fibrous reinforcing agent; a mineral filler; a stabilizer; a mold release agent; a dye; a pigment; a flame retardant; or a mixture of any of the foregoing.

15           23. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is a butadiene-methyl methacrylate-styrene copolymer.

20           24. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is a butyl acrylate-methyl acrylate copolymer.

25           25. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is an acrylonitrile-butadiene-styrene copolymer.

30           26. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is a styrene-butadiene-styrene block copolymer.

35           27. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is a radial teleblock copolymer of styrene and butadiene.



28. A composition according to Claim 18 wherein the rubbery vinyl addition polymer is an acrylonitrile-butadiene-methyl methacrylate-styrene copolymer.

5           29. A thermoplastic molding composition comprising (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin, and a minor proportion of (b) a poly(carbonate-co-silicone) resin combined with (c) a poly(carbonate-co-ester) resin, the combined amounts of (b) and (c) being effective to  
10 increase the impact strength of articles molded from said component (a).

          30. A composition according to Claim 29 which also includes (g) a polyester copolymer.

15           31. A thermoplastic molding composition comprising (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin and a minor proportion of (b) a polycarbonate resin, combined with (c) a poly(carbonate-co-silicone) resin, the combined  
20 amounts of (b) and (c) being effective to increase the impact strength of articles molded from said component (a).

          32. A thermoplastic molding composition comprising (a) a poly(C<sub>2-6</sub> alkylene terephthalate) resin and  
25 a minor proportion of (b) a rubbery polybutyl acrylate-methyl methacrylate copolymer in combination with (c) a polycarbonate resin, the combined amounts of (b) and (c) being effective to increase the impact strength of articles molded from said component (a).

30           33. A composition according to Claim 1 wherein the rubbery vinyl addition polymer comprises polybutadiene units.

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34. A composition according to Claim 33 wherein the poly(C<sub>2-6</sub> alkylene terephthalate) resin is poly(ethylene terephthalate).
- 5           35. A composition according to Claim 33 wherein the poly(C<sub>2-6</sub> alkylene terephthalate) resin is poly(1,4-butylene terephthalate).
- 10           36. A composition according to Claim 33 wherein the poly(C<sub>2-6</sub> alkylene terephthalate) resin is a polyester copolymer.
- 15           37. A composition according to Claim 33 wherein the butadiene polymer is an acrylonitrile-butadiene.
38. A composition according to Claim 33 wherein the polycarbonate resin is a poly(bisphenol-A carbonate) resin.
- 20           39. A composition according to Claim 33 wherein the polycarbonate resin is a poly(carbonate-co-silicone) resin.
40. A composition according to Claim 33 wherein the butadiene polymer is an isobutylene-(2-methylbutadiene) copolymer.
- 25           41. A composition according to Claim 33 wherein the butadiene polymer is polybutadiene.
- 30           42. An article molded from a composition according to Claim 1.
43. An article molded from a composition according to Claim 29.
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44. An article molded from a composition  
according to Claim 31.

45. An article molded from a composition  
5 according to Claim 32.

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